

**IN THE CLAIMS:**

*Please replace claims 1 and 2 with the corresponding amended claims:*

- Sub C1  
A2
1. (Amended) A method of dry milling a material comprising:  
providing a silicon nitride based cutting tool insert;  
cutting at a cutting speed of 1000-3000 m/min; and  
feeding to a cutting depth of 0.2-2 mm,  
wherein the material comprises aluminum and cast iron.
  2. (Amended) The method of claim 1, wherein the cutting tool insert produces  
a chip thickness of 0.09-0.17 mm.

*Please add new claims 3 and 4 as follows.*

- Sub C1  
A3
3. (New) A method of dry milling a composite material, the method  
comprising:  
providing a silicon nitride based cutting tool insert;  
cutting at a speed of 1100-2500 m/min; and  
feeding to a cutting depth of 0.2-2 mm.
  4. (New) The method of claim 3, wherein the cutting depth is 0.3-1.0 mm.

3608.924 ft/min  
8202.1 ft/min

0.0118" - 0.0394"